<b>Work Orde</b> February-11-14				*1130	<b>108</b> *						Page 1
Item ID: Revision ID:	D3536-25			Accept	*N900	0040	100	)* ፡	Setup Sta	I VI	S1*
Item Name:	Gasket Center		<u> </u>		,				Sto	<sup>p</sup> *N	S2*
Start Date:	2/10/14	<b>Start Qty:</b> 10.00	*10*		Cust Item	ID:					
Required Date: Reference:	2/10/14	<b>Req'd Qty:</b> 10.00	*10*		Customer:	1					
Approvals:	Process Pla	n: MLJ	Date: 14-02-12	Tooling:	D	ate:	_	I	Run Sta	"IVI	R1*
	QC:	•	Date:	SPC (Y/N):	D	ate:			Sto	<sub>b</sub> *N	R2*
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D3536	Rev	A									
100 <b>*100*</b> Waterjet FLOW CNC Waterje	et	FLOW WATER JET  Memo  1-Cut as per Deburr if nea	Dwg D3536 Dwg Rev:_ cessary	0.00 Prog Rev:	_ 2-			13	0		Jm14-02-2
110		QC2- Inspect parts off m	achine FAI/FAIB	0.00							
*110* QC Quality Control		Memo		0.00				13	٥		JM14-02-2
<sup>120</sup> *12∩*		QC8- Inspect parts - seco	and check	0.00 <b>DAS</b> 27 9-89				13			
QC		Memo		16/2/D1 00.0							

Quality Control

DQA:			Date:												$ \mathcal{L}_{\mathcal{A}} \wedge \mathbb{R}^{\mathcal{L}} $
OA Classel			Data			WORK ORDER NON	-C(	ONFO	RMANCE / UP			0.1			AEROSPACE
QA Closed:			Date:			·					Work	Order up	odate only		
Work Order	r:					DISPOSITION				AGAINST	DEPA	RTMENT	/PROCESS		
	_					Rework	1		Skid-tube	Crosstube			Water Jet	$\neg$	Engineering
Part No	0.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor.	$\exists$	Quality
	_				<del></del>	Use-as-is	1	1	moforming	Finishing			re/Packaging	一	Other
NCR No	o					Suspected Unapproved	]		Large Fab	Composite			Supplier		
						<u> </u>								_	
Root					Desc	ription of work order update		Initial	Actio	on		Sign &			
Cause	4	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verification	ו	QC Inspector
Design	4														
Doc/Data	4						1								
Equip/Tooling	4														
Handling/Pre	-														
Material	$\dashv$														·
Operator Offset/Setup	$\dashv$														
Process	$\dashv$														
Supplier	_														
Training	-			·											
Transport	╗										1				
Unapproved	╗														
					•		FA	ULT CA	TEGORY	•					
Landin	g Ge	ear				General		. ,							
	∏в	ending				Bend		Folio/F	Program			utside Dim	ensions		Pressure/Forced
	_]c	entre No	ot Concer	itric		BOM/Route		Grain			O	ver/Under	tolerance		Set-up
	c	Cracks				Broken/Damage/Defect		Hardwa	are		Pa	art Incorre	cí		Temperature/Cure
<u> </u>	c	rimp/Kin	ık/Ripple,	/Wave		Burrs		Inspect	ion Incomplete/Und	qualified	Pa	rt Lost/Mi	issing		Weld
]	→	Cuffs				Contamination		Instruct	tions Incomplete/U	nclear	Pa	art Moved			Wrong Stock Pulled
	_	crushing				Countersink		Misalig	gned/off center		Pc	ositioned V			
	_	leat Trea				Cut Too Short		Mislabe	eled		P0	ower Loss/	Surge		Other
	_		n Strip in	Tube		Drawing	$\perp$	Misrea			_				
	_	//arks/Ch				Drill Holes		Off-set						_	
		urning S				Finish	$\vdash$	4	Calibration		_				70.41 T. H
	Į۷	Vave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence						

Work Orde February-11-14				*113	R008*							Page 2
Revision ID:	D3536-25 Gasket Center			Accept	*N900	<b>040</b>	100	)*	Setup	Start	17	S1* S2*
Start Date: Required Date: Reference:	2/10/14 2/10/14	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item I Customer:	D:						
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		nte:			Run	Start Stop	^IV	R1* R2*
Sequence ID/ Work Center ID 130 *120* Packaging Packaging	)	Operation Description Identify as per dwg & Sto	ck Location: FP-6(	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	t Re Q	eject ty	Reject Number	Insp. Stamp

140

QC21- Final Inspection - Work Order Release

0.00

\*140\*

Memo

0.00

MF MJ-21

Quality Control

DQA:			Date:											A DT
						<b>WORK ORDER NON</b>	-CO	ONFO	RMANCE / UPD	DATE			<u>(</u>	ROSPACE
QA Closed:			Date:							W	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
	•					Rework	1		Skid-tube	Crosstube	1	Water Jet	Engine	ering
Part N	lo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.		uality
						Use-as-is	]	Thern	moforming	Finishing	Rec/Sto	re/Packaging		Other
NCR N	10.					Suspected Unapproved	]		Large Fab	Composite	]	Supplier		
Root					Desc	ription of work order update		Initial	Action	n	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descript	tion	Date	Verification	QC Ir	spector
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Doc/Data														
Equip/Tooling						•								
Handling/Pre														
Material		`												
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Offset/Setup														
Process														
Supplier				}	-									
Training														
Transport														
Unapproved											<u> </u>			
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Landi		ī			_	General	_	1	_	<del> </del>	<del>-</del>	г		_
		Bending			-	Bend	<u> </u>	-	Program	<u> </u>	Outside Dim	F	Pressure/	Forced
		Centre No	ot Concer	ntric	·	BOM/Route	<u></u>	Grain		_	Over/Under		Set-up	
		Cracks			-	Broken/Damage/Defect	<u> </u>	Hardwa			Part Incorred	F	<b></b> 1 '	ture/Cure
	-	Crimp/Kir	nk/Ripple	/Wave	-	Burrs	<u> </u>	1	ion Incomplete/Unqu		Part Lost/Mi	<b>-</b>	Weld	
	_	Cuffs			-	Contamination	$\vdash$	4	tions Incomplete/Unc	clear	Part Moved		Wrong St	ock Pulled
	· .	Crushing			$\vdash$	Countersink	_	1 1	gned/off center		Positioned V		¬	
	_	Heat Trea		T., b -	<u> </u>	Cut Too Short	$\vdash$	Mislabe		L	Power Loss/	Surge [	Other	
	-	Inspectio	•	ıupe	$\vdash$	Drawing	$\vdash$	Misrea						
		Marks/Ch				Drill Holes	$\vdash$	Off-set						
	<u> </u>	Turning S	-		_	Finish	-	-{	Calibration					
	<b>.</b>	Wave/Tw	vist in Tub	)면		Fit/Function	1	JOut of :	Sequence					

**Picklist Print** 

February-11-14 3:16:49 PM

Page 1

Work Order ID: 113008

\*113008\*

Parent Item:

D3536-25

\*D3536-25\*

Parent Item Name: Gasket Center

**Start Date: 2/10/14** 

Required Date: 2/10/14

**Start Oty: 10.00** 

Required Qty: 10.00

**Comments:** 

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	27.1000	0.5956	6 <del>.61777</del>	8		
*MNFO60	S 063*								**	9.		Ji	n14-02.

**NEOPRENE SHEET 0.063** 

Location	Loc Qty	Loc Code	
MAT052	27.1		
M126546	27.1		
128266			128266

DQA:			Date:											$\mathcal{L}_{\mathcal{A}}$ of	
						<b>WORK ORDER NON</b>	-C(	ONFO	RMANCE / UF	PDATE				AEROSPACE	
QA Closed:			Date:							W	ork Order up	date only			
Mante Onda					-	DISPOSITION			AGAINST DEPARTMENT/PROCESS						
Work Orde	er: .					Rework			Skid-tube	Crosstube	1	Water Jet	$\neg$	Engineering	
Part N	ı					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	-	Engineering Quality	
raiti	٠٠.					Use-as-is			noforming	Finishing	-	e/Packaging	$\dashv$	Other	
NCR N	lo.					Suspected Unapproved		111011	Large Fab	Composite	- 1100	Supplier	$\dashv$		
	•						ı				J		_		
Root	1				Desc	ription of work order update		Initial	Acti	on	Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	ո	QC Inspector	
Design															
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Equip/Tooling							ļ						- 1		
Handling/Pre															
Material															
Operator									1						
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Landi		1				General		3 <i>.</i> .	_	_	٦.	1	_	· 1	
		Bending	_		-	Bend		-1	Program	ļ	Outside Dim		_	Pressure/Forced	
		Centre No	ot Concer	ntric		BOM/Route	<u> </u>	Grain		ļ	Over/Under			Set-up	
		Cracks			-	Broken/Damage/Defect	<u> </u>	Hardwa			Part Incorred		$\vdash \vdash$	Temperature/Cure	
		Crimp/Kir	nk/Ripple	/Wave	$\vdash$	Burrs	<u> </u>	<b>ተ</b>	ion Incomplete/Un	· —	Part Lost/Mi	ssing	-	Weld	
	_	Cuffs			<u> </u>	Contamination	L	-	tions Incomplete/U	Inclear	Part Moved		Ш	Wrong Stock Pulled	
		Crushing				Countersink	$\vdash$	-	gned/off center	<u> </u>	Positioned V	- 1	_	1	
	<u> </u>	Heat Trea		<b>-</b> L	-	Cut Too Short	$\vdash$	Mislab		<u> </u>	Power Loss/	Surge		Other	
		Inspectio		Tube	-	Drawing	-	Misrea							
	<u> </u>	Marks/Ch			-	Drill Holes	$\vdash$	Off-set							
	_	Turning S			<u> </u>	Finish	<u> </u>	Out of Calibration							
	Wave/Twist in Tube Fit/Function		Fit/Function		Out of	Sequence									

DART AEROSPACE LTD	Work Order: 1/3008	
Description: Gasket	Part Number: D3536-2	5
Inspection Dwg: D3536 Rev: A	Page 1 of	1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.80	+/-0.030	21.80"	_		T	Thomas
16.35	+/-0.030	16.35	-		T	
10.90	+/-0.030	10.900	_		+	
5.45	+/-0.030	5.45	_		ν	
6.00	+/-0.030	6.00"	_		ν	
6.75	+/-0.030	6.75	_	17	ν	
12.75	+/-0.030	19.75"	_		T	
1.89	+/-0.030	1.89			v	-
0.30	+/-0.030	0.30	_		ν	
0.30	+/-0.030	0.30	_		ν	
Ø0.19	+0.005/-0.001	0.19	_		<b>V</b>	

Measured by:	Im	Audited by:	27	Prototype Approval:	N/A
Date: /	14-07-21	Date:	14/2 9-89/2/	Date:	N/A

Rev	Date	Change	Revised by Approved
Α	07.06.13	New Issue	KJ/JLM X

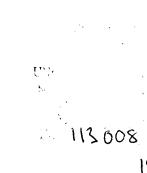
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26.65 23.15 21.15 17.65 13.40 0.90 -- 5.65 · 1.89 DETAIL A 3.90 ø0.19 (TYP 3 PLS) D3536-11 GASKET

113008 MCJ 1402-12







CHECKED

3

D3536 DRAWING NO.

SHEET 1 OF 6

SCALE

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DART

AEROSPACE PORT HADLOCK,

USA,

RC.

06. DATE

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GASKET

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06.10.25

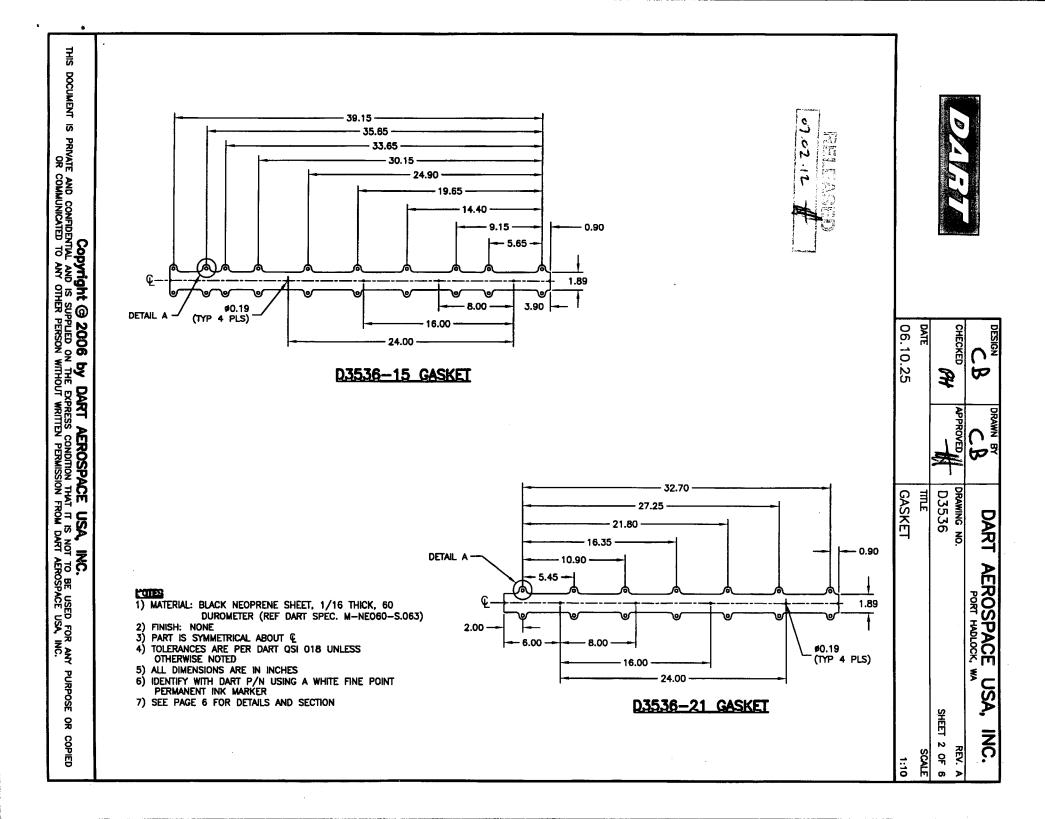
NEW ISSUE

32.90
29.40
27.40
23.90
18.98
14.07 9.15 0.90 1.89 14.00 14.00

D3536-13 GASKET

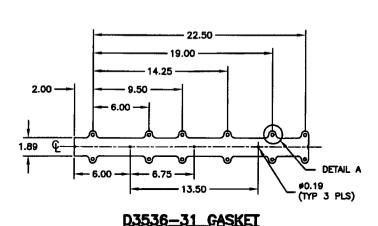
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- PART IS SYMMETRICAL ABOUT & TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
  6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

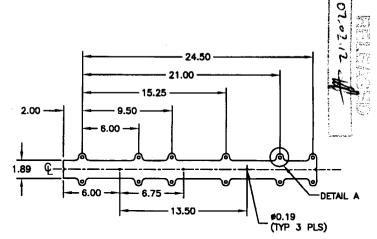
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PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. 33.92 28.53 -23.14 - 17.75 -14.25 -DETAIL A 4.75 -2.00 1.89 - 6.00 06.10. DATE CHECKED 0.90 - 16.00 #0.19 (TYP 6 PLS) - 24.00 - 32.00 .25 田 B 39.00 48.00 APPROVED D3536-23 GASKET D3536 GASKET DRAWING NO Ħ DART 21.80 1.45 16.35 DETAIL A AEROSPACE PORT HADLOCK. 10.90 R0.06 (TYP) 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063) 2) FINISH: NONE THIST. NOTE
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 THIST. NOTE 1.89 RO.25 -- 6.00 (TYP) 5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER 0.90 **PURPOSE** (TYP 3 PLS) 7) SEE PAGE 6 FOR DETAILS AND SECTION D3536-25 GASKET SHEET 욹 **⊼** COPIED 3 OF 6 SCALE 1:10





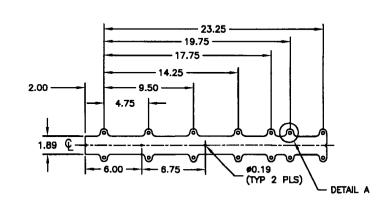
D3536-33 GASKET

OIPS						
) MATERIAL:	BLACK	NEOPRENE	SHEET,	1/16	THICK,	60
•	DURON	METER (REF	DART S	SPEC.	M-NEO6	i0-S.063)

2) FINISH: NONE 3) PART IS SYMM

2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT 
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-35 GASKET



GASKET 1:10		06.10.25
TITLE SCALE		DATE
D3536 SHEET 4 OF 6	TI	OH
DRAWING NO. REV. A	APPROVED #	CHECKED
PORT HADLOCK, WA	CB	CB
DART AEROSPACE USA. INC.	DRAWN BY	DESIGN

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DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. 07.02.12 27.25 22.50 17.75 2.00 4.75 Ç 1.89 6.00 8.00 16.00 DETAIL A 21.00 06.10.25 (TYP 4 PLS) D3536-37 GASKET B 3 35.71 32.78 29.28 DRAWING NO. 25.78 GASKET 23.25 DART 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEOBO-S.063) 19.75 2) FINISH: NONE 2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT &
4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
PERMANENT INK MARKER 2.00 -AEROSPACE PORT HADLOCK, 1.88 7) SEE PAGE 6 FOR DETAILS AND SECTION #0.19 (TYP 3 PLS) -- 5.00 DETAIL A 28.00 USA, D3536-39 GASKET HEHE 엻 ₹ C COPIED σ SCALE 우 6 1:10

07:02.12

## D3536-41 GASKET

(TYP 2 PLS)

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27.98 25.08

18.50

15.00

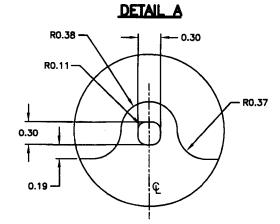
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DETAIL A

2.00 -

4.00 -

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60
  DUROMETER (REF DART SPEC. M-NEO60-S.083)
- 2) FINISH: NONE 3) PART IS SYMM
- PART IS SYMMETRICAL ABOUT & TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
  6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



1:10	GASKET		06.10.25
SCALE	TIME .		DATE
SHEET 6 OF 6	D3536	#	¥
REV. A	DRAWING NO.	APPROVED //	CHECKED
DART AEROSPACE USA, INC.	DART	CB	CB

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